

split

Date: Wednesday, 10/10/2007 11:03:45 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR FWD RH
Job Number : 35083	
Estimate Number : 11234	
P.O. Number :	Part Number : D32812
This Issue : 10/10/2007 S.O. No. :	Drawing Number : D3281 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / 1 Type : THERMOFORMING	Drawing Revision : 8
Previous Run : 33898	Material :
Written By :	Due Date : 11/2/2007
Checked & Approved By :	Qty: 20 Um: Each
Comment : Est Rev A 04.07.01 New issue KJ/JLM	
Est Rev B 07.08.07 Thermoform in house DL	

*UNDER REVIEW
OR TO PRODUCE
LE 07.10.12
LE 08.01.07*



9410

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 F6006701 lexan black



Comment: Qty.: 4.3600 sf(s)/Unit Total : 87.2000 sf(s)
lexan black .125"

Material Batch # *M 106713*

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



x10

Comment: HAND FINISHING THERMOFORMING

Wh 08.01.05

1) Cut Blanks

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

x10

Thermoform as per Dwg. D32811 and Folio FTA 008

Wh 08.01.05

Dwg. Rev. *C*
Folio Rev. *B*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



x10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Wh 08.01.05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 11:03:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR FWD RH

Job Number: 35083

Part Number: D32812

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

X10

08.01.07

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

X10

08.01.07

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 07.10.12

RELEASED 08.01.07

AUTH 08.01.07

DATE 08.01.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

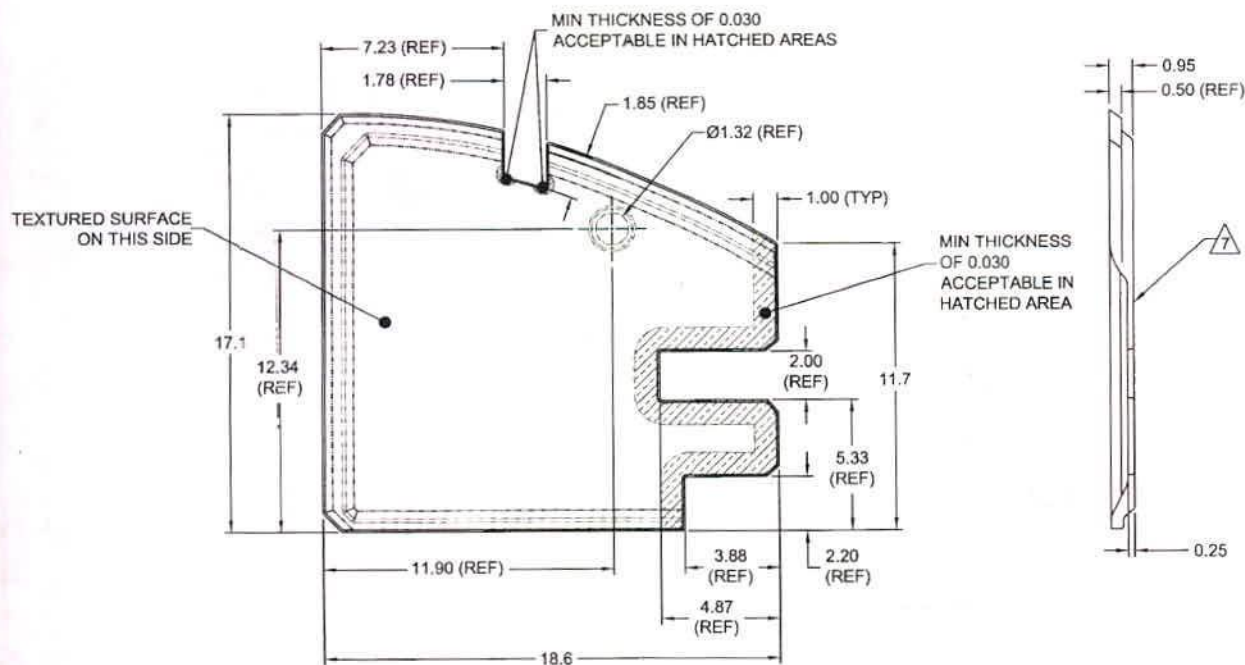
NOTE: Date & initial all entries

RELEASED
07-11-06

D3281-1 NOTES:

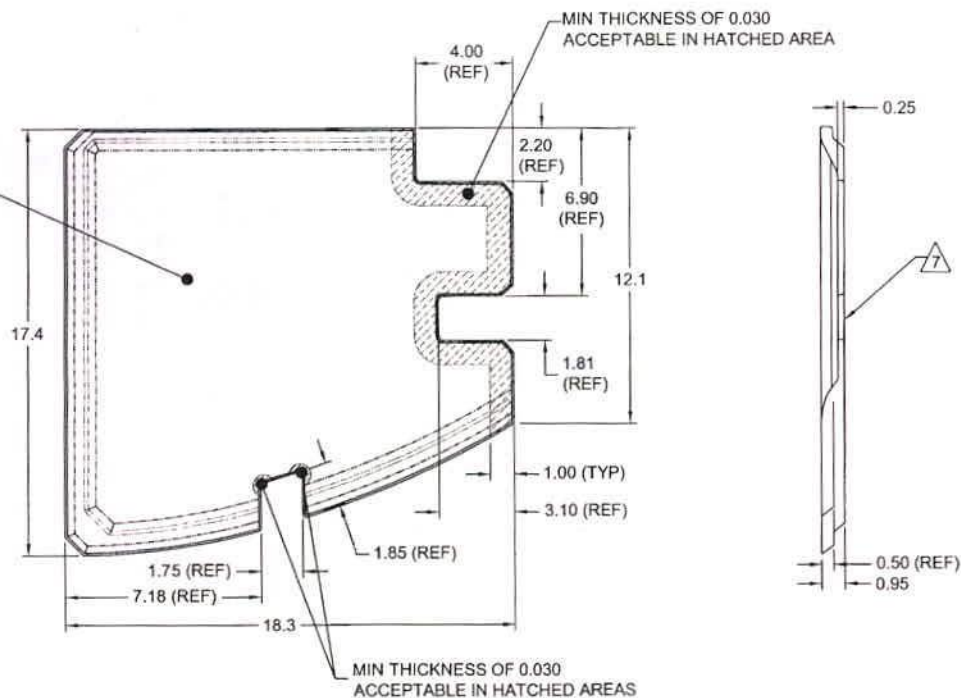
- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FIN SH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

D3281-1 FLOOR PROTECTOR



C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	pt		
MFG. APPR.	WJH		
APPROVED	WJH		
DE APPR.	WJH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DATE	07.10.09	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	

TEXTURED SURFACE
ON THIS SIDE



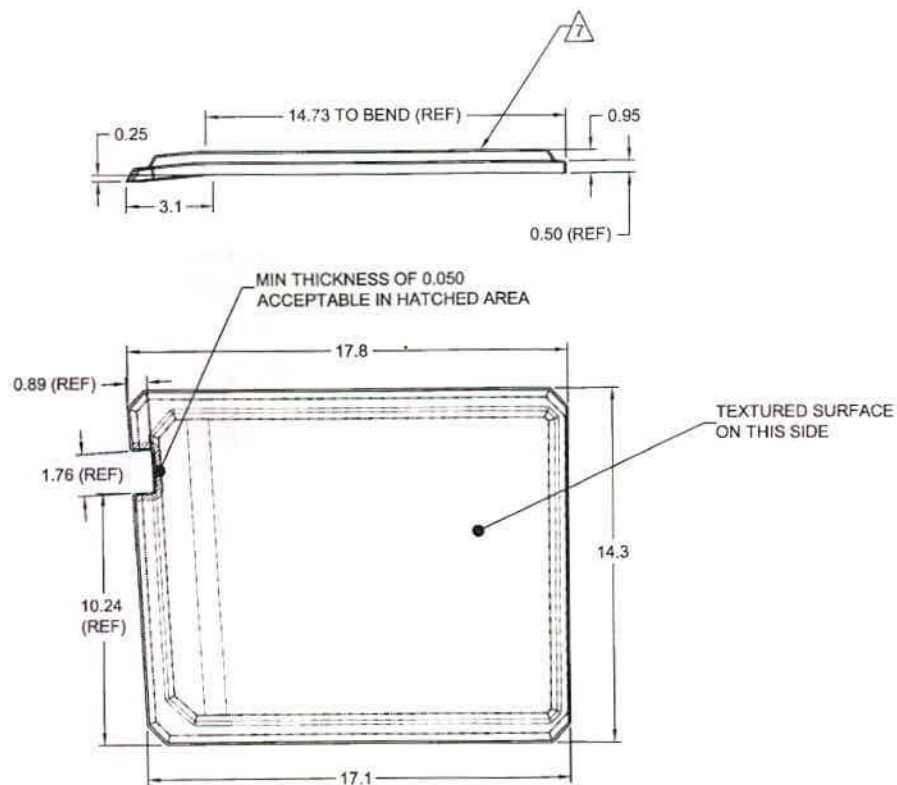
D3281-2 FLOOR PROTECTOR

RELEASED
07.11.06

D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	4P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	PE	DRAWING NO.	REV. C
MFG. APPR.	PE	D3281	SHEET 2 OF 3
APPROVED	PE	TITLE	SCALE
DE APPR.	PE	FLOOR PROTECTOR	NTS
DATE	07.10.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



RELEASED
07-11-06

D3281-3 FLOOR PROTECTOR
(D3281-4 OPPOSITE)

D3281-3/-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QS' 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/-4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	42	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	WJD	D3281	SHEET 3 OF 3
APPROVED	WJD	TITLE	SCALE
DE APPR.	WJD	FLOOR PROTECTOR	NTS
DATE	07.10.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order: 35083
Description: R44 FLOOR PROTECTORS. FWD RH.		Part Number: D3281-2
Inspection Dwg: D3281	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 3/16"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: D. Lopez	Date: 08.01.05
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	.1	18.3	✓			
17.4	.1	17.4	✓			
12.1	.1	12.1	✓			
0.95	.030	0.958	✓			
0.25	.030	0.243	✓			

Measured by: D. Lopez	Date: 08.01.07
Audited by: 08.01.07	Date: 08.01.07
Prototype Approval: N/A	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	